

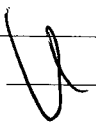
Work Order ID 130203

130203

Page 1

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Item ID: D3136-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Window Assembly
 Start Date: 2/26/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 3/06/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3136	F								
100	FLOW WATER JET	0.00				4	0		JM15-3-10
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
	Dwg Rev: <u>F</u>								
	Prog Rev: <u>F</u>								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				4	0		JM15-3-10
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

4 0 JM15/03/15

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 Start Date: 2/26/15 Start Qty: 4.00 ***4*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	THERMOFORMING MACHINE	0.00							
130						4			B15/03/11
Thermoform	Memo	0.00							
Thermoforming Machine	1-Deburr if necessary								
	2-Thermoform as per Dwg D3136 and Work Instruction WI002								
	Dwg Rev. <u>F</u>								
	WI Rev. <u>E</u>								
	3- Engrave Part # and Batch # , and affix labels (D3136-3)								
140	HAND FINISHING THERMOFORMING	0.00							
140						4			B15/03/11
Thermoform	Memo	0.00							
Thermoforming Machine	Water sand and buff to remove scratches as required								

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Item ID: D3136-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Window Assembly
 Start Date: 2/26/15 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 3/06/15 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Inspect edge and window deformation, wrap in plastic	0.00 0.00				(4)			DAS 38 9-89 MAR 17 2015
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <u>SH35</u> Memo	0.00 0.00				4			DAS 6 9-89 MAR 18 2015
190 *190* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							MCS 15-03-18 AD 15.3.18

Picklist Print

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Work Order ID: 130203

130203

Parent Item: D3136-043

D3136-043

Parent Item Name: Window Assembly

Start Date: 2/26/15

Required Date: 3/06/15

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A04.02.04New issueKJ/DS
IPP Rev.B 07.05.29 Thermoform in-house DL
IPP rev C 07.09.28 Rev E dwg EC verified by:DD IPP Rev:D
10.06.24 added note in qc5 seq 170 DD verf:EC IPP Rev E 14/01/20
Replace "Folio" with Work Instruction DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3108-9		Manufactured	No			100	Each	347.0000	2	8		15/03/11	
D3108-9									**	8			
Decal													

Location

Loc Qty

Loc Code

ST017

347

46546

347

MACRLICS.125

Purchased

No

170

sf

152.1670

3.9

16

MACRI ICS 125

1/8" Polycast II Sheet

Jm15-3-10

Location

Loc Qty

Loc Code

MAT019

152.167

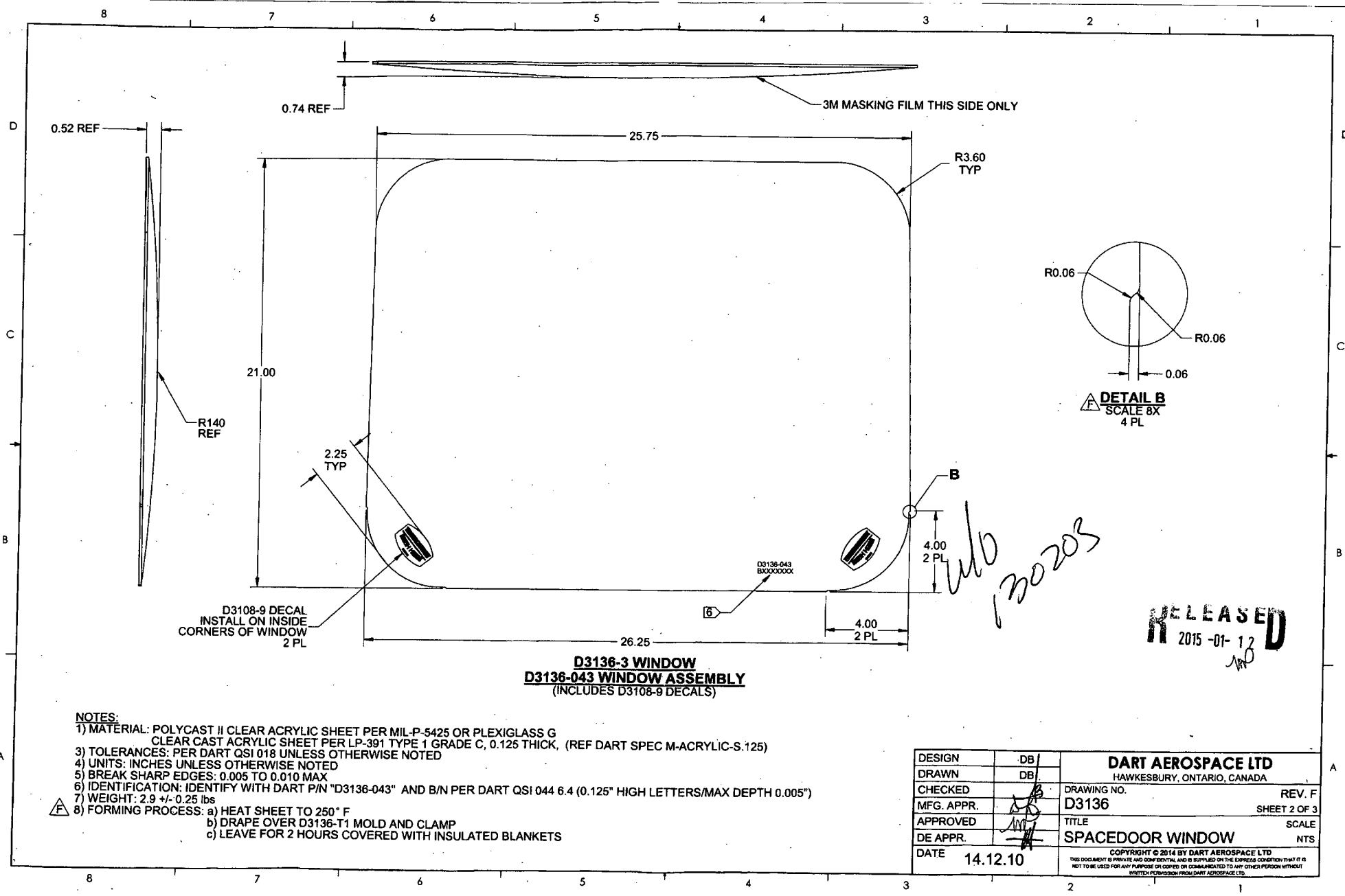
m130047

24.667

m131524

127.5

31524



D3136-3 WINDOW
D3136-043 WINDOW ASSEMBLY
(INCLUDES D3108-9 DECALS)

- NOTES:**
- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLASS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK, (REF DART SPEC M-ACRYLIC-S.125)
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3136-043" AND B/N PER DART QSI 044 6.4 (0.125" HIGH LETTERS/MAX DEPTH 0.005")
 - 7) WEIGHT: 2.9 +/- 0.25 lbs
 - 8) FORMING PROCESS: a) HEAT SHEET TO 250° F
b) DRAPE OVER D3136-T1 MOLD AND CLAMP
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	DB	DRAWING NO.	REV. F
MFG. APPR.	DB	D3136	SHEET 2 OF 3
APPROVED	DB	TITLE	SCALE
DE APPR.	DB	SPACEDOOR WINDOW	NTS
DATE	14.12.10	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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2015-01-13